December 10, 2009 11:51:48 AM

Item ID:

D212-664-101

Accept



Setup Start

Stop



Revision ID

Start Date:

Item Name: Crosstube Fwd

Required Date: 28/12/2009

10/12/2009

QC:

Start Oty: 1.00 keq'd Qty: 1.00



Gust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: 1911-1

Tooling:

SPC (Y/N):

Date:

Date:

Run

Start

Stop



Sequence ID/ Work Center ID Operation

Set Up/

Draw

Draw Rev.

Plan Code Accept

Reject Reject

Insp. Number

Draw Nbr

Description

Revision Nbr

Rev D

Date:

Run Hours

Number

Qty

Oty

Stamp

D212-664-141 100

Document Control

DOCUMENT CONTROL

Memov

0.00

0.00

Photocopy bluefile and create labels as per PPP D212-664-101 CHG003

110

Packaging Packaging

Pick Kit

Packaging

Memo

0.00

0.00

120

CNC Bend 2

BENDING MACHINE - CROSSTUBES

Memo

0.00

0.00

CNC Alpha 160 Bender

Bend tube as per Dwg D212-664-141 using CNC bender program 212-fw and Folio FT015

MB 09-12-

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W/O: WORK ORDER CHANGES								***
DATE	STEP	PRO	CEDURE CHANGE		Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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NCR:				N-CONFORMANC			-	
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December 10, 2009 11:51:48 AM

Required Date: 28/12/2009

Item ID:		
Revision	ID	:

D212-664-101

Accept



Setup Start



Stop

Item Name: Start Date:

Crosstube Fwd 10/12/2009

QC:

Start Qty: 100 Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run

Stop



Sequence ID/

Work Center ID

Operation Description QC15- Crosstube Dimensional Check Set Up/ **Run Hours** Draw . Number

Draw Plan Rev. Code

Accept Qty

Reject Qty

Reject Insp. Number Stamp

130

Memo

0.00

0.00

0.00

Quality Control

140

Crosstubes

Crosstubes

Crosstubes

Memo

0.00

1-Drill pilot holes in tube as per Dwg D212-664-141 using drill Jig DT8548 & DT8549

2-Ream hole to finish size in tube as per Dwg D212-664-141using drill Jig DT8548 & DT8549. Check dimensions between holes, both sides on both cuffs, to ensure alignment with saddle holes.

3-Scribe part # and batch # using vibrating stylus as per Dwg D212-664-141

4-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D212-664-141

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W/O:				V	ORK ORDER	CHANGES				ı	"		
DATE	STEP		PROCI	EDURE CH	IANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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Required Date: 28/12/2009

Item ID: Revision ID:

D212-664-101

Crosstube Fwd

Accept



Setup Start



Stop

Item Name: Start Date:

10/12/2009

Start Qty: 1.00 Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals

Process Plan: _____ Date: ____

Operation

Tooling:

SPC (Y/N):

Date:

Date:

Run

Start

Stop

Sequence ID/

Work Center ID

Description Crosstubes Chemical Conversion Set Up/ **Run Hours**

Draw Number

Plan Draw Code Rev.

Accept Qty

Reject Qty

Reject Insp. Number Stamp

150

HandFXtube

Hand Finishing Crosstubes

Memo

0.00

0.00

_____ Date:

Chemical Conversion Coat within 24 hours of bending and drilling

160

Quality Control

QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

170

Outsource2

Outsource process - NDT

Outsource process - NDT per QSI038 4.1

0.00

0.00

Liquid Penetrant Inspection as per QSI 038

Issue P/O: 1012

LPI as per ASTM 1417 Level 2

Attach copy of NDT results to work order

CX 10/0/64 0

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W/O:			WC	RK ORDER CHANG	ES					
DATE	STEP	PRO	CEDURE CHAI	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		PAR #: Fault Category: NCR: Yes No DQA: Date Resolution: Disposition: QA: N/C Closed: Date WORK ORDER NON-CONFORMANCE (NCR)								
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Part No) :	PAR #:	Fault Cate	gory:	_ NC	R: Yes	No DQ	A:	Date: _	
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		Description of NC		Corrective Action Secti	on B		Verifi	cation	Annroval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	 	Sign & Date		ion C	Chief Eng / Prod Mgr Date: Date:	QC Inspector
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Item ID:

D212-664-101

Accept

Setup Start



Stop



Insp.

Stamp

Revision ID:

Item Name: Start Date:

Crosstube Fwd

10/12/2009

Start Qty: 1.00

Required Date: 28/12/2009

Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

0.00

SPC (Y/N):

Date: Date: Run

Start

Reject

Qty

Stop

Reject

Number

Draw Draw Plan Accept Set Up/ Qty Code Number Rev. **Run Hours**

Sequence ID/ Work Center ID

180

Packaging Packaging

Operation Description

Receive & Inspect for Damage & Mat'l Certs

Packaging

0.00 Memo

Date:

Ensure copy of NDT results attached to work order.

190

Quality Control

OC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Inspect for damage & ensure results are as per Dwg D212-664-141

Dart Ae	rospace	Ltd						
W/O:			W	ORK ORDER CHANGE	S			
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	Date Qt	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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••	R	esolution:	Disposition	on:	QA: N/C Cld	sed:	Date: _	
NCR:	******	\	WORK ORD	DER NON-CONFORMAL	NCE (NCR)		
		Description of NC		Corrective Action Section		Verification	n Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector

December 10, 2009 11:51:48 AM

Required Date: 28/12/2009

Item ID:

D212-664-101

Accept

Setup Start



1 3

Accept

Qty

Stop

Reject

Revision ID:

Item Name: Seart Date:

Crosstube Fwd

10/12/2009

Start Qty: 1.00

Req'd Qty: 1.00



Date:

Cust Item ID:

Customer:

Draw

Number

Reference:

Approvals:

Process Plan: _____ Date:

Tooling:

SPC (Y/N):

Date:

Date:

Draw

Rev.

Plan

Code

Reject

Qty

Run



Number Stamp

Insp.

Stop

Sequence ID/ Work Center ID

200

SprayPaint

Spray Painting

Operation Description

Spray Painting per QSI005 4.2

Memo

SprayPaint

Set Up/ **Run Hours**

0.00

0.00

1-Prime inside and outside crosstube as per QSI 005 4.2 2-Paint outside crosstube with White Imron as per QSI 005 4.2

PRIME:

Start Time:_8:30 Fininsh Time: 9:30

PAINT:

Start Time: 2:30 Finish Time: 3:3 0

210

QC14- Inspect Spray Paint

0.00



Quality Control

Memo

0.00

Then, Wrap in plastic bag to protect from scratches

RT 10-01-06

Dart Aerospace	ŀ	_td
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W/O:			W	ORK ORDER CHANG	ES				 :					
DATE	STEP	PRO	CEDURE CHA	NGE	Ву	Da	te Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspêctor					
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Part No	:	PAR #:	Fault Cate	gory:	NCR: Ye	es No	DQA:	_ Date: _						
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DATE	STEP	Description of NC			tion B	V	erification	Approval	Approval					
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December 10, 2009 11:51:48 AM Setup Start Accept Item ID: D212-664-101 Revision ID: Stop Crosstube Fwd Item Name: Start Qty: 1.00 **Cust Item ID:** Start Date: 10/12/2009 · W Requireu Date: 28/12/2009 Req'd Qty: 1.00 Customer: Reference: Start Run Tooling: Date: Process Plan: Date: Approvals: Date:_____ SPC (Y/N): Date: Reject Reject Insp. Draw Plan Accept Draw Operation Set Up/ Sequence ID/ Qty Qty Number Stamp Code Number Rev. **Run Hours** Work Center ID Description 0.00 220 Crosstubes 0 0 00.00 Crosstubes Memo 1- Lightly scuff the bonded area using a 320 grit sand paper and clean the area Crosstubes with 41058 wash 'n' wipe 2-Install supports with magnobond as per QSI 015 Adhere for for L2 Hrs A/R 6398 Magnobond Batch: 112417 ew:01/2011 Torque Widoll of () OC5- Inspect part completeness to step on W/O 230 2) 500/01/07 0.00 Memo Quality Control 0.00 Pick Kit 240 10-1-8 (10 \$/ 0.00 Packaging Memo Packaging

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W/O:		WORK ORDER CHANGES												
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Part No	•	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A :	_ Date: _						
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D.475	0750	Description of NC			tion B	Verific	cation	Approval	Approval					
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Insp.

December 10, 2009 11:51:48 AM Accept Setup Start Item ID: D212-664-101 Revision ID: Stop Item Name: Crosstube Fwd **Start Date:** 10/12/2009 Start Oty: 1.00 **Cust Item ID:** Required Date: 28/12/2009 Rea'd Oty: 1.00 Customer: Reference: Start Run Process Plan: Date: Tooling: Date: Approvals: Stop OC: Date: SPC (Y/N): Date: Set Up/ Plan Accept Reject Reject Draw Draw Sequence ID/ Operation Qty Code Oty Number Stamp Number Rev. Work Center ID Description **Run Hours** OC4- 100% Inspect kits for completeness 250 27 Stokela8 Memo **Ouality Control** (v es/os/os O 0.00 260 Packaging 0.00 Packaging Memo Identify and pack for shipping as per PPP D212-664-101 Packaging

270

OC21- Final Inspection - Work Order Release

0.00

Memo

Quality Control

0.00

- 10/01/10 A)

Dart Ae	rospace	Ltd								
W/O:			, W	ORK ORDER CI	HANGES					
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		Description of N	C	Corrective Action	Section B		Verifica	tion	Approval	Approval
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Picklist Print						•	r		Page 1
December 10, 2009 11:51:53 AM					200				
Work Order ID: 54503									
Parent Item: D212-664-101									
Parent Item Name: Crosstube Fwd						St	art Date: 1	10/12/2009	Required Date: 28/12/2009
Comments: IPP RevH: as per ECN09-696 09	9.11.19 DE	verified by:E	C			S	Start Qty: 1	1.00	Required Qty: 1.00
Component Item ID/ Resilacement Mfg/ Item Name Item ID Purch	Bin Item	Primary Location	Last Location	Ro ∉e Seq ID	Unit of Measure	Qty on Hand	Remainir Qty To P		Date Status Issued
D212-664-101TRN Manufactu	red No			110	Each	3.0000	1.0000	1 5050	1-51-90 dm
Crosstube Turning Detail							1188111985	3-5450	
		Warehou	<u>se</u>	Loc	<u>Oty</u>	Loc Code			
• .		Locat	<u>tion</u>						
		Main War	rehouse						
		FG	_		3				-
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D3595-063-450 Manufactu	red No		34204	230	Each	188.9689	4.2105		-
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		Main Wa	rehouse						m(10/01/06
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		Main Wa	rehouse						
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2.59

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	- John J									*	
W/O:			W	ORK ORDER CHANG	GES					· (*)	
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DATE	STEP	Description of NC			ction B	0	Verific		Approval	Approval	
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Picklist Print

Page 2

December 10, 2009 11:51:53 AM

Work Order ID: 54503

Parent Item:

D212-664-101

Parent Item Name:

Crosstube Fwd

Comments:

IPP RevH: as per ECN09-696 09.11.19 DD verified by:EC

Start Date: 10/12/2009

Required Date: 28/12/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item Name	i	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	் இait of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Statas
MS21920-25			Purchased	No			220	Each	201.0000	4.0000			
								,					•

Clamp(per MIL-DTL-8783C)

Warehouse	Loc Qty	Loc Code	
Location		İ	
Main Warehouse			
ST	201		
107456	2		
108111	3		
108975	17		
109181	42		
109644	10		
111282	4		
111429	1		
112495	22		
112919	25		
113281	25		
113282	50		

Dart Ae	rospace	e Ltd							
W/O:			N	ORK ORDER CHANGE	S				- }
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December 10, 2009 11:51:53 AM

Work Order ID: 54503

Parent Item:

D212-664-101

Parent Item Name:

Crosstube Fwd

Comments

IPP RevH: as per ECN09-696 09.11.19 DD verified by:EC

Manufactured

Start Date: 10/12/2009

Required Date: 28/12/2009

Start Qty: 1.00

Required Qty: 1.00

Compone Item Nan	nt Item ID/	Replacement Item ID	Ning/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of #! Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status	
D2893-1			Manufactured	No			220	Each	71.0000	2.0000				
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2.75 Support

Warehouse	<u>Lo</u>	c Oty	Loc Code		Λ	
Location					m(salas las
Main Warehouse						10/01/06
ST		71				,
25657		6				
47109		2				
<u>47637</u>		15				
51775		19				
53125		19				
53340		10		:		
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Placard

Warehouse Loc Oty Loc Code
Location

Main Warehouse

ST096

6 50790 11 11 10-1-8 5

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W/O:			WC	RK ORDER CHANG	ES				. ۱۰۰م غ
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December 10, 2009 11:51:53 AM

Work Order ID: 54503

Parent Item:

D212-664-101

Parent Item Name:

Comments

Crosstube Fwd

IPP RevH: as per ECN09-696 09.11.19 DD verified by:EC

Purchased

No

Start Date: 10/12/2009

Required Date: 28/12/2009

Start Qty: 1.00

Loc Code

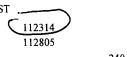
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Required Qty: 1.00

Componen Item Name	1	Replacement Item ID	Mfg/ Purch	A C		Primary Location	Last Location	Route Seq ID	Unit of Measure	Qt;∕∕o⊓ Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN6-35A	 		Purchas	sed	No			240	Each	58.0000	4.0000 	10-1-8	sf	



Warehouse Loc Qty Location Main Warehouse 58 ST .



38 20 240 Each

16-1-8

AN6-36A Bolt

Loc Qty Loc Code Warehouse

Location Main Warehouse ST 123 109632 110382 112314 70 50

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W/O:	-		W	ORK ORDER CI	HANGES				· · · · · · · · · · · · · · · · · · ·	•
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Part No	•	PAR #:	Fault Cate	egory:	NC	R: Yes	No DQ	A:	Date:	
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December 10, 2009 11:51:54 AM

Work Order ID: 54503

Parent Item:

D212-664-101

Parent Item Name:

Crosstube Fwd

Comments:

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IPP RevH: as per ECN09-696 09.11.19 DD verified by:EC

105077

Start Date: 10/12/2009

Required Date: 28/12/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item	_	-	\ Zin	Primary	Last	Route	Unit of Measure	Qty on Hand	Maining Qty To Pick	Qty Issued	Date Issued	Status
Item Name	Item ID	Purch	Item	Location	Location	Seq ID	Measure		1	155464		
MS21042L6		Purchased	No			240	Each	500.0000			_	. 1
										10-1	-8 S	0
Nut									i	, ,	1	•
				Warehou	<u>ise</u>	Loc	<u>Oty</u>	Loc Code	:			
				Loca	tion							
				Main Wa								
				ST,			500					

110002 111548 400 65 240 Each No AN960JD616 Purchased

Warehouse Location Main Warehouse

ST

787.0000 18.0000

Loc Code

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December 10, 2009 11:51:54 AM

Shop Packet Print

Loc Oty

787

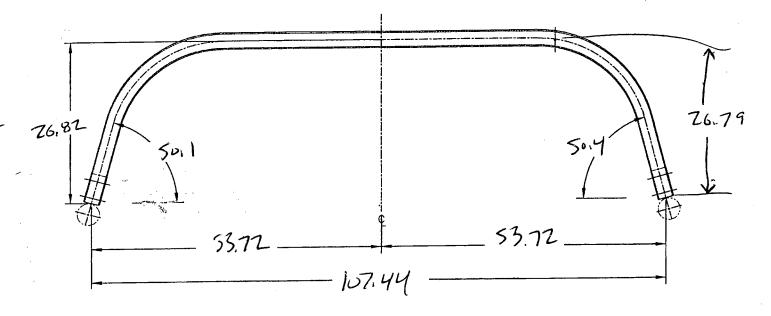
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W/O:				WORK O	RDER CHANGES)				****
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DART AEROSPACE LTD	Work Order:	54503
Description: Crosstube High Fwd (205/212/412)	Part Number:	D212-664-101
Inspection Dwg: D212-664-141 Rev: C		Page 1 of 1

Required Dimension	Min	Max
Height	26.79	27.05
1/2 Span	53.59	53.85
Angle	49	52
Total Span	107.18	107.7



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	OC15 Inapportion		///			
_	QC15 Inspection Date		<u> </u>			
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Rev	Date	Change	Revised by	Approved
Δ	07.02.06	New issue	KJ/JM ,	1
B	07.05.31	Dimensions updated per Dwg Rev C	KJ/JM OK	hu
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[·] NOTE: Date & initial all entries

Item	Qty -141	Qty -141B	Part Number	Description
1	Xit	,	D212-664-141	CROSSTUBE ASSEMBLY (205/212/412 HIGH (#/D)
2		X	D212-664-141B	CROSSTUBE ASSEMBLY (214 HIGH FWD)
3	1	1	D6005-128	CROSSTUBE
4	2	2	D2893-1	SUPPORT
5	4	4	D3595-063-450	RUBBER CUSHION
6	4	4	MS21920-25	CLAMP (OR MS21920-26)
7	A/R	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

GENERAL NOTES:

1) MATERIAL: MANUFACTURED FROM D6005-128

FINISHED LENGTH = 126.514±0.020

2) FINISH: CHEMICAL CONVERSION COAT PER DART OSI 005 4.1 PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2

PAINT OUTSIDE PER DART OSI 005 4.2

- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED. 4)
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- IDENTIFICATION: SCRIBE DART PART NUMBER "D212-664-XXX" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS
- WEIGHT: D212-664-141 = 33.6 lbs (PER IIN-D212-664) D212-664-141B = 33.6 lbs (PER IIN-D212-664)
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- RUN CUTTER OFF PART. BLEND OUT EDGE LONGITUDINALY, TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 3 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTAL D2893-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2893-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTAL L MS21920-25 CLAMPS (OR -26) WITH D3595-063-450 RUBBER CUSHIONS TO SECURE THE D2893-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE OF CROSSTUBE. SUPPORT.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS, DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

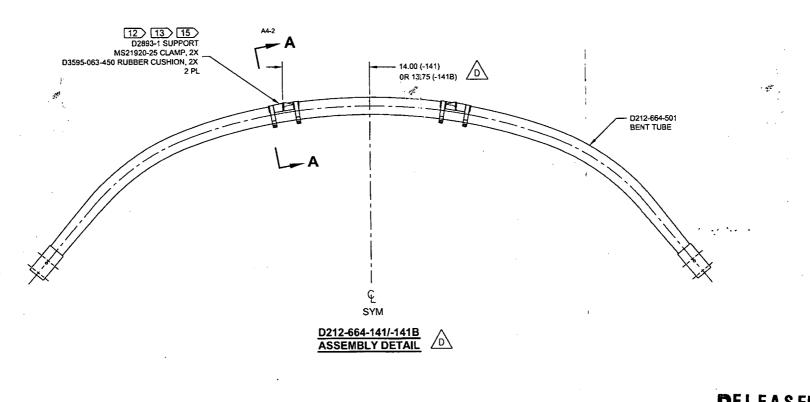
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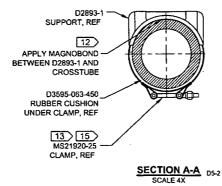
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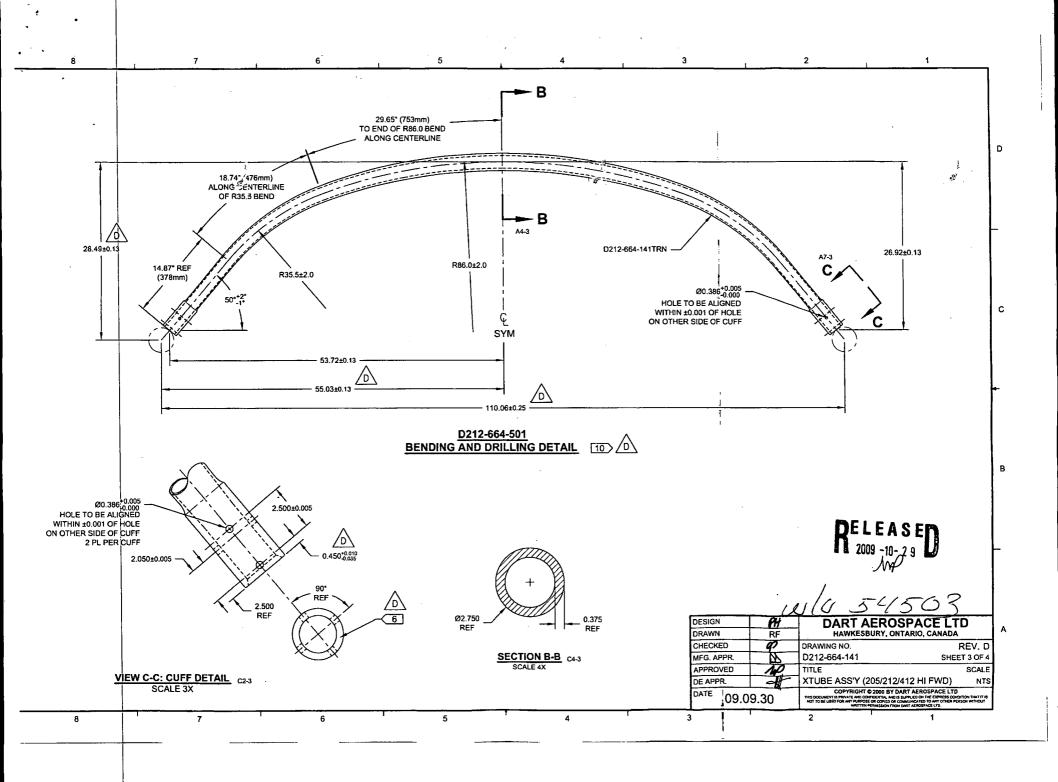
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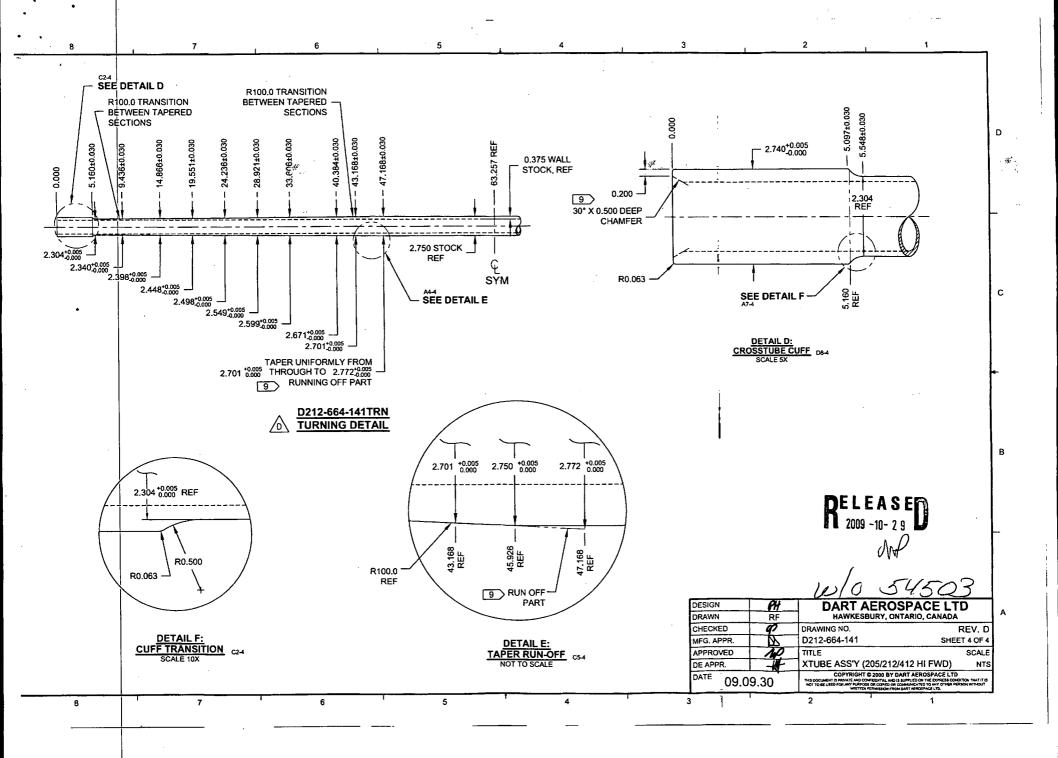
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